

Date: Thursday, 6/15/2006 1:42:19 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HEAD REST	
Job Number	: 27568		Part Number	: D3303041	
Estimate Number	: 10738		Drawing Number	: D3303 REV. A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/15/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 7/30/2006 Qty: 1 Um: Each	
Previous Run	: 26689				
Written By	: JLM				
Checked & Approved By	: 06-06-15				
Comment	: Est: B 04.10.05 Revised Step 5 with headrest indentification K J/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	Batch
1.0	D3303043	Bracket Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) BRACKET ASSEMBLY			
Pick: Qty Part Number Description Batch 1 D3303-043 Bracket Assembly B 26690 ① B 27589 ② B 28113 ④			
2.0	D33051	Cushion	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) FOAM CUSHION			
Pick: Qty Part Number Description Batch 1 D3305-1 Cushion B 26695 ⑦			
3.0	D3306041	Cover Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) COVER ASSEMBLY			
Pick: Qty Part Number Description Batch 1 D3306-041 Cover Assembly B 26690 ⑦			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA: Date: 06/01/08

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 6/15/2006 1:42:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST

Job Number: 27568

Part Number: D3303041

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/1300L or 8046 adhesive.

Identify as D3303-041 418532

2- Cover Head Rest with D3306-041 as per Dwg D3303

SB 06/12/06 (7)

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Mo 06/12/06 (7)

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a permanent fine point marker as per Dwg D3303, then Stock

Location: 514981351380

SB 06/12/06 (7)

7.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/12/06 (7)

Job Completion



SB 06/12/06 (7)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

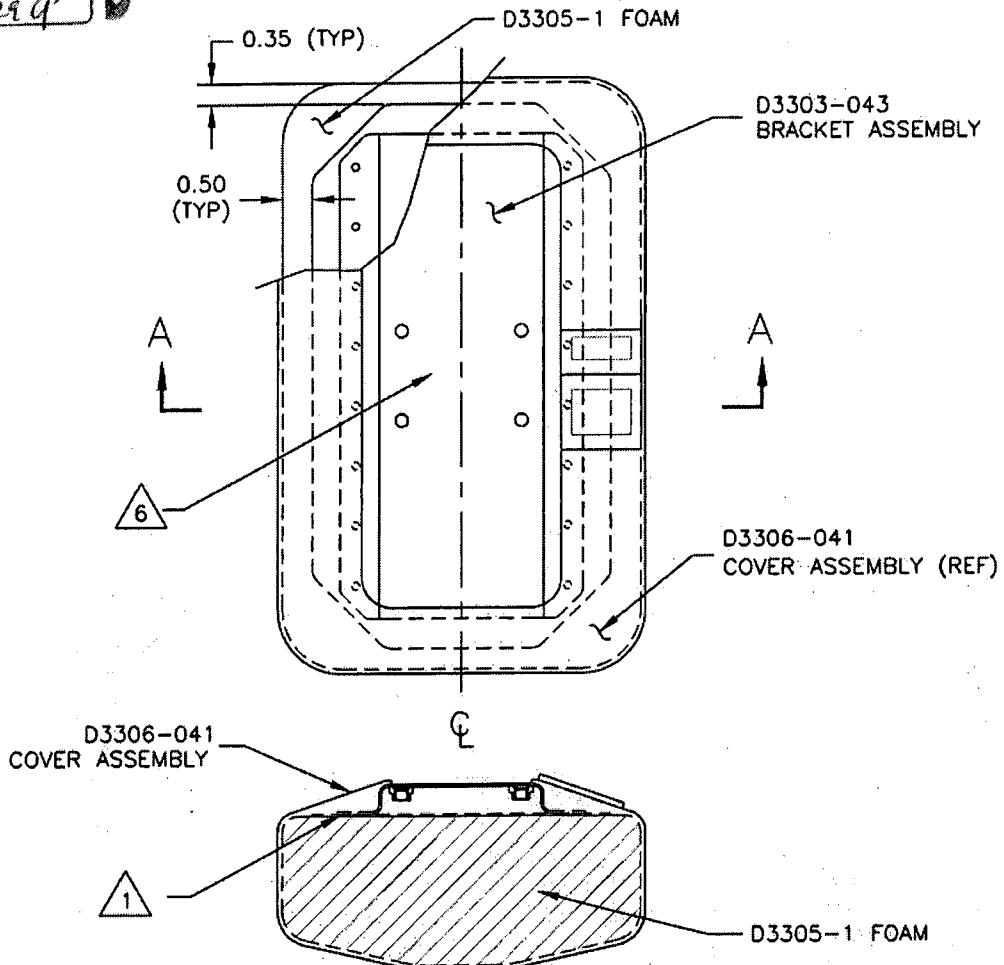
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. A SHEET 1 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:3
A	04.08.18	NEW ISSUE	

RELEASED
04.09.29 6P**SECTION A-A****D3303-041 HEAD REST****D3303-041 NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE CONTROLLED COPY (0.002" to 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS. SUBJECT TO AMENDMENT
- 2) COVER HEAD REST WITH D3306-041 AS SHOWN
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT
ELIGIBILITY SEE PDA0411"

SHOP COPY

RETURN TO

ENGINEERING

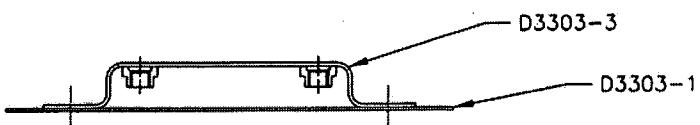
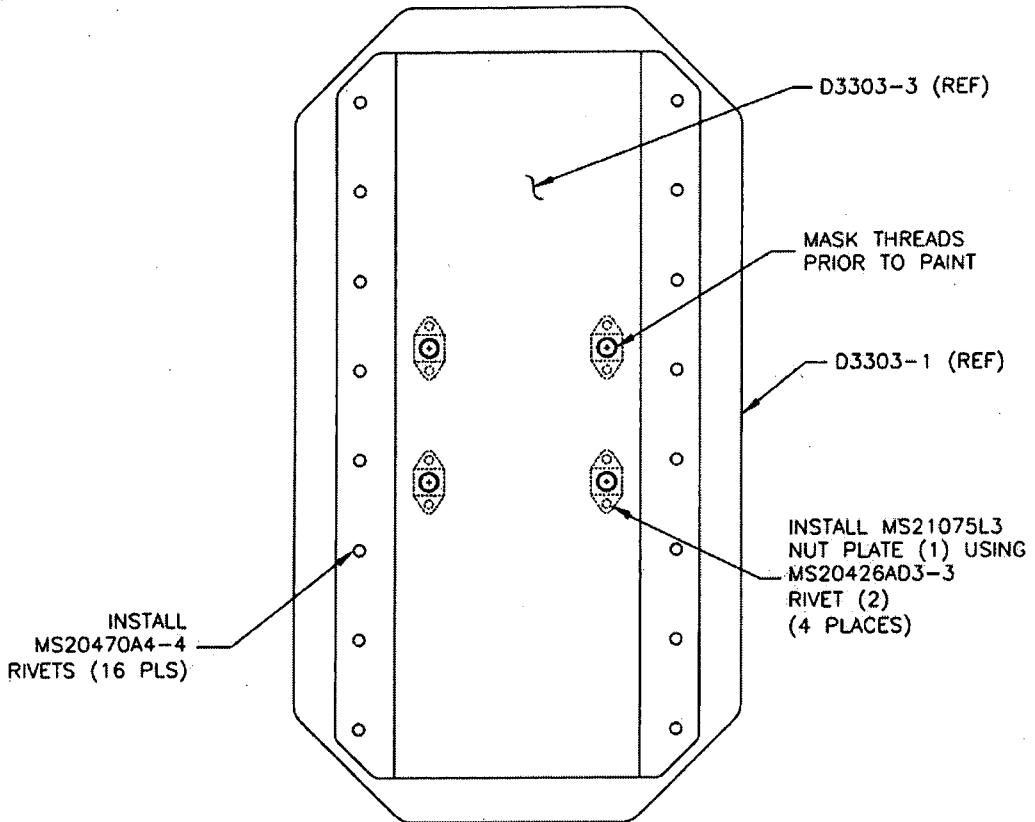
WITHOUT NOTICE

WORK ORDER

NO. *21568*

DART

DESIGN RF	DRAWN BY HF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED HF	DRAWING NO. D3303	REV. A SHEET 2 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:1

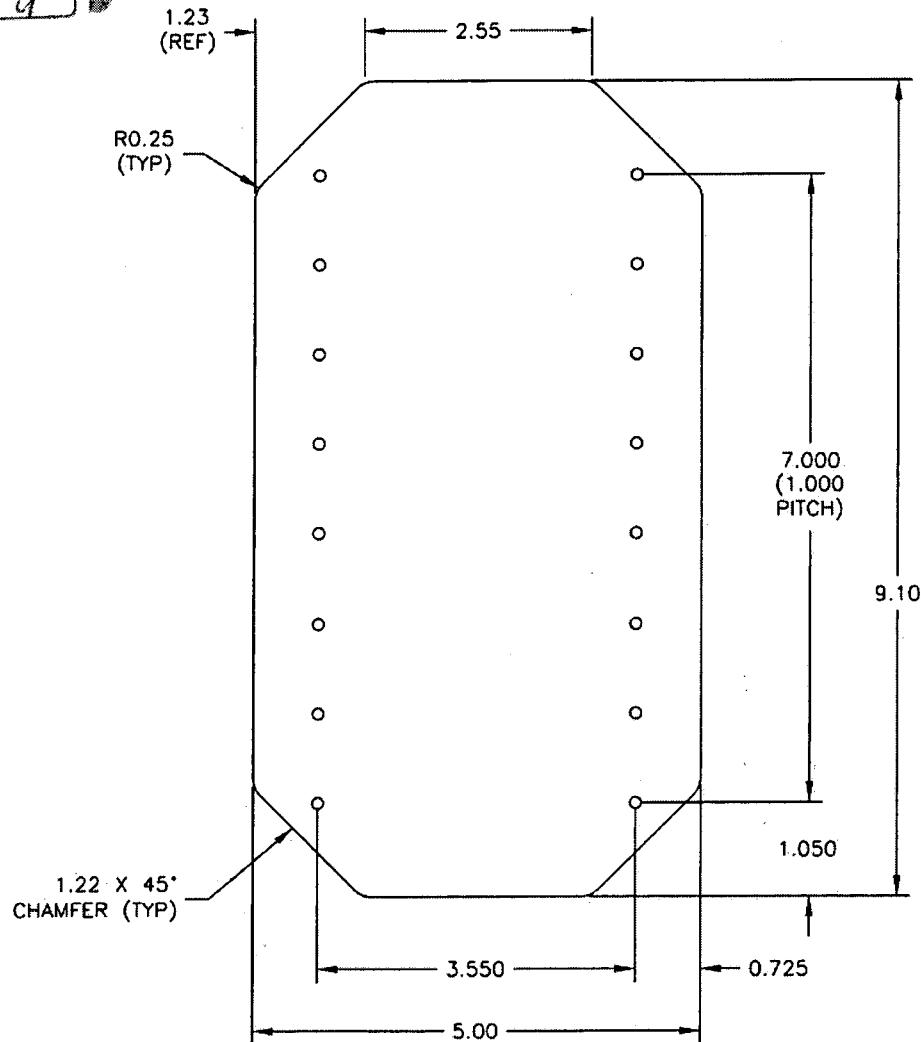
RELEASED
04.09.29 AP**D3303-043 BRACKET ASSEMBLY****D3303-043 NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *27568*

DART

DESIGN <i>H</i>	DRAWN BY <i>H</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3303	REV. A	SHEET 3 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2	

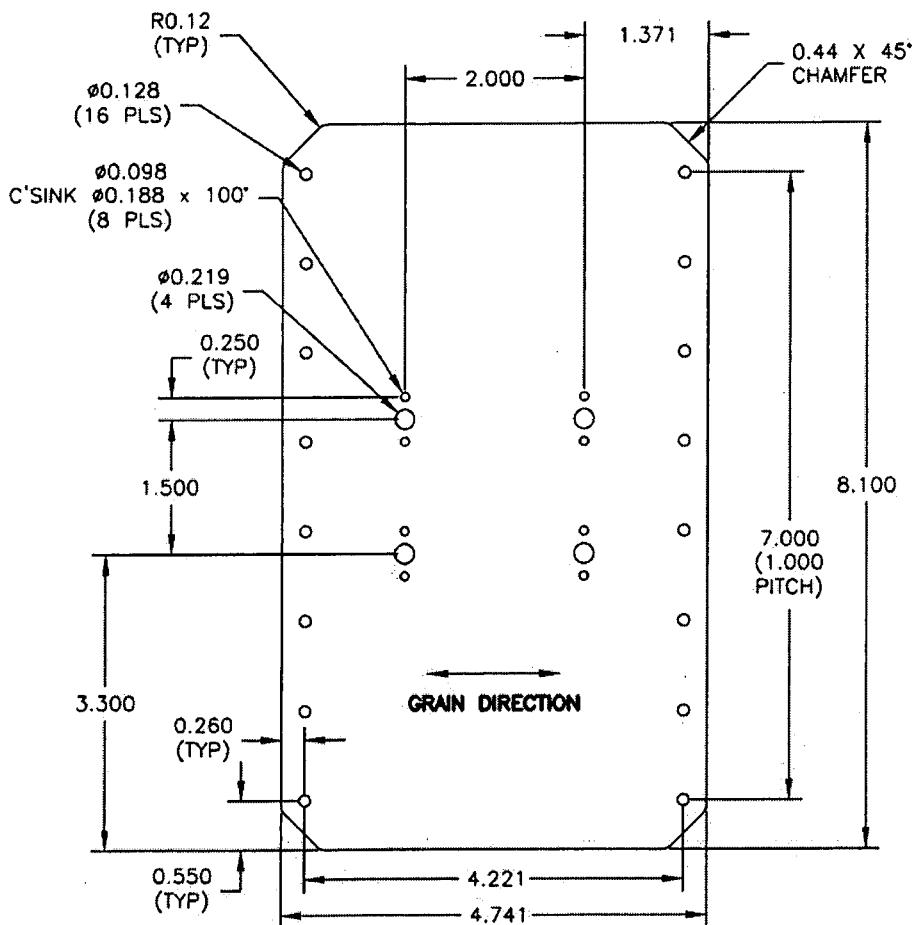
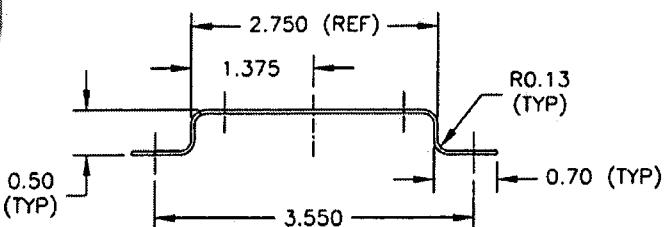
RELEASED
04.09.29 UP**D3303-1 PLATE****D3303-1 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *29568*

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. A SHEET 4 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

**D3303-3 FLAT PATTERN****RELEASED**
04.09.29 (P)**D3303-3 BRACKET BEND DETAIL****D3303-3 NOTES:**

- 1) MATERIAL: 2024-T3 (00-A-250/4) 0.040 THICK SHEET (REF. DART SPEC M2024T32S040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27568